

# Work Order ID 71562

Wednesday, July 06, 2011 1:18:27 PM



Page 1

Item ID: D2807-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door prop

Start Date: 7/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CZ Date: 11/07/06

Tooling:

Date:

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2807

Rev E

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14435 ☐ Order as per Dwg D2807 ☐ Possible  
supplier: Lift Support Technologies, Saskatoon, Canada ☐ P/N 6/15-164/50-115N

☐

Material release note is required

CZ 11/07/06 (20)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

P4/7/8 (20)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

5 mo 7/08

(auto)  
(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71562

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Item ID: D2807-041

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Item Name: Door prop

Start Date: 7/6/2011 Start Qty: 20.00



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Required Date: 7/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-install D3671-1 as per dwg D2807

*EP 11/07/18* (20)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*Counts*  
(+20)

150



Packaging

Packaging

Identify as per dwg & Stock Location: 022

0.00

Memo

0.00

*P 11/17/18* (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71562**

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Wednesday, July 06, 2011 1:18:27 PM

Item ID: D2807-041

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Setup Start



Revision ID:

Stop



Item Name: Door prop

Start Date: 7/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/7/18

11-07-18  
20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, July 06, 2011 1:18:25 PM

Page 1

Work Order ID: 71562

Parent Item: D2807-041

Parent Item Name: Door prop



Start Date: 7/6/2011

Required Date: 7/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD  
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3671-1  Placard		Manufactured	No			110	Each	6.0000	1	20			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				6					
					69680			6					
6/15-164/50-115N  Gas Spring		Purchased	No			130	Each	0.0000	1	20			

*Handwritten notes:*  
 7/5/11/07/18  
 B 71757 (142)  
 6  
 6/4/7/8 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

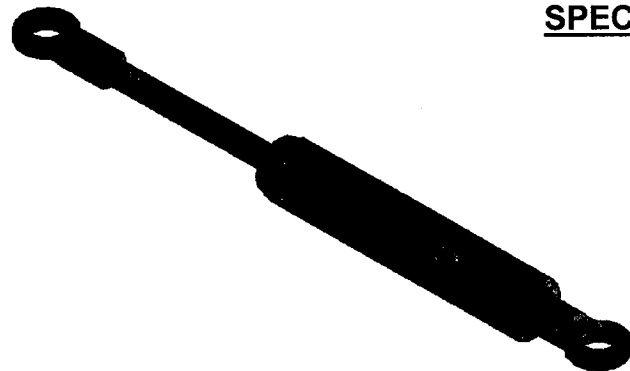
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# SPECIFICATION CONTROL DRAWING



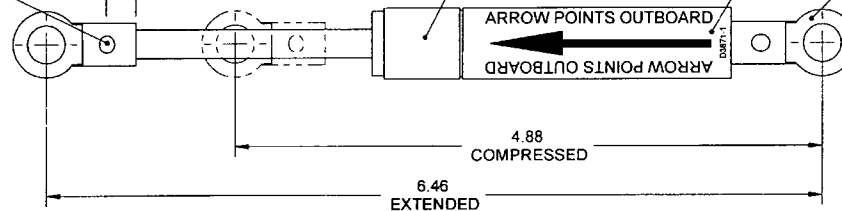
(ALTERNATE ONLY)  
CRIMP 0.015-0.025 DEEP  
WITH  $\varnothing 0.375$  TOOL AT  
2000psi (REF), TYP TWO  
SIDES PER LUG

0.24 TO CRIMP  
(TYP)

D2807-5  
OR  
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD  
ENSURE PLACARD DOES NOT  
CONCEAL ANY TEXT OR MARKINGS  
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3  
BOTH ENDS



**D2807-041 GAS SPRING**

RELEASED  
05-12-10

## D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

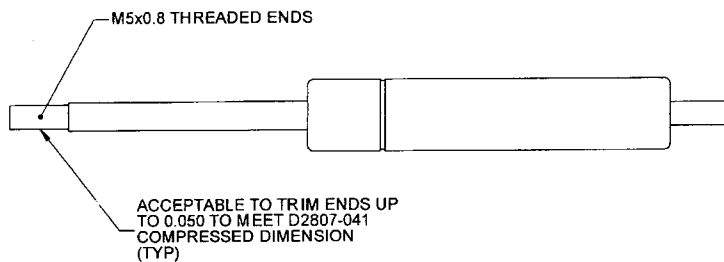
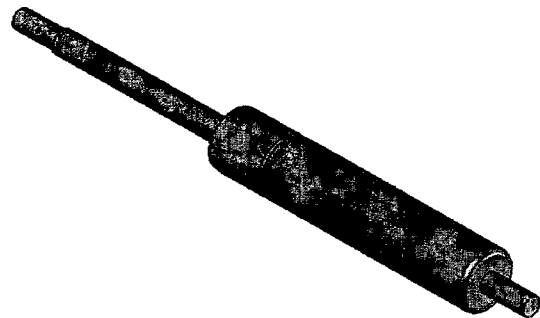
### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)  
(WEIGHT: 0.176 LBS)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71562

C211107104

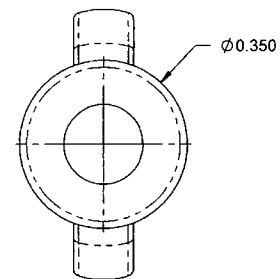
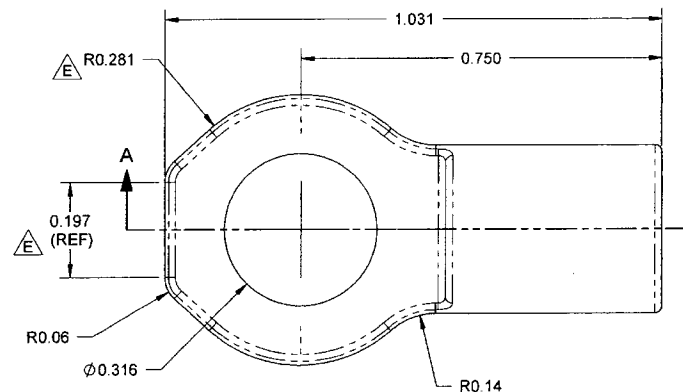
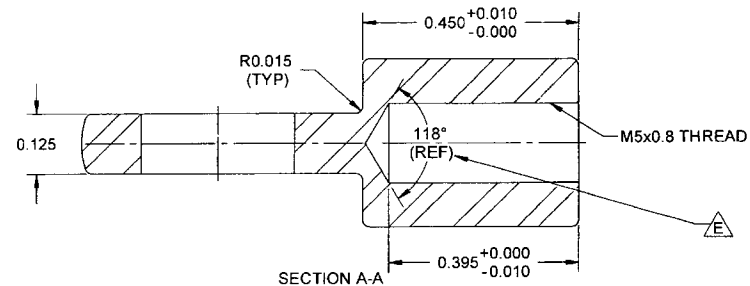
E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWS	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AY		
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	MP	D2807	SHEET 1 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	GAS SPRING	NTS
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



**D2807-1 GAS SPRING**  
SCALE 1:1

**D2807-1 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK  
(P/N SXF6S6050080S6L-115N)  
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX  
M5x0.8 THREADS

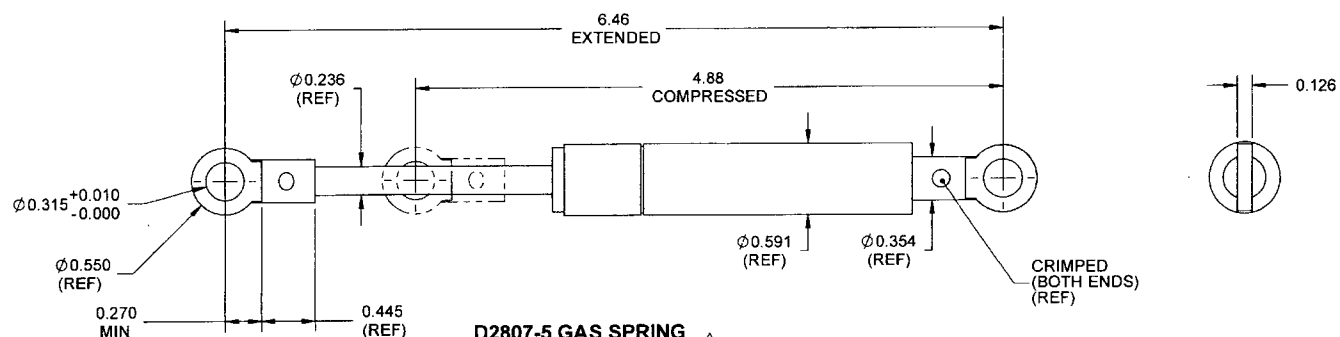
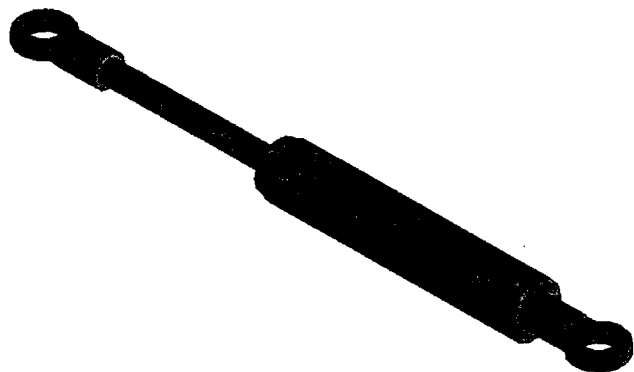


**D2807-3 LUG**

**D2807-3 LUG NOTES:**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	#	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	#		
CHECKED	#	DRAWING NO. <b>D2807</b>	REV. E
MFG. APPR.	#	SHEET 2 OF 3	
APPROVED	#	TITLE <b>GAS SPRING</b>	SCALE 4:1
DE APPR.	#	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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**D2807-5 GAS SPRING** 

**D2807-5 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS.  
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	HE	DRAWING NO. <b>D2807</b>	REV. E
MFG. APPR.	HE	SHEET 3 OF 3	
APPROVED	HE	TITLE	SCALE
DE APPR.	HE	<b>GAS SPRING</b>	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO14435

Purchase Order Date 7/6/2011

PO Print Date 7/6/2011

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.  
303-103 STREET  
SASKATOON, SK S7N 1Y9  
CA

Contact Name

Vendor Phone 306 683 5000

Vendor Fax 306 683 6403

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

*CL 11/16/11*

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	7/8/2011 Yes	20.00 Each	FedEx PI collect	\$63.9000	\$1,278.00

Special Inst: AS PER DWG D2807 REV. E  
B71562

PO Total:

\$1,278.00



Change Nbr: 1

Change Date: 7/6/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

LS Technologies Canada Inc.

303 - 103 Street  
Saskatoon, SK Canada  
S7N 1Y9

# Packing Slip

Date	Invoice #
7/6/2011	7450

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
PO14435	7/6/2011	Fed-Ex		

Qty	Description
20	6/15-164/50-115N ( D2807 Rev E ) Stainless Gas Spring Shipping Via FED EX Tracking #797275596451  S M 07/10/11



303 - 103<sup>rd</sup> Street, Saskatoon, Saskatchewan, Canada S7N 1Y9  
Ph: (306) 683-5000 Fax: (306) 683-6403

### Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

20 Units: 6/15-164/50-115N ( D2807 Rev E ) Stainless Gas Spring

Country of Manufacture: Canada  
Date of Manufacture : July 2011  
This product is ROHS compliant.

*8*  
*W2102*

We certify no mercury was used in the manufacture of this order.

Purchase Order # 14435  
Invoice # 7450

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Mark Ingram", written over a horizontal line.

Mark Ingram  
Manager